

03–327 Replacing rear crankshaft radial oil seal

Tightening torques	Nm
Necked down screw for camshaft gear	80
Connecting rod nuts	initial torque
	angle of rotation torque
Necked down screws for flywheel or driven plate	initial torque
	angle of rotation torque
Crankshaft bearing bolts	80

Self-made tool

Gage	see fig., point 4
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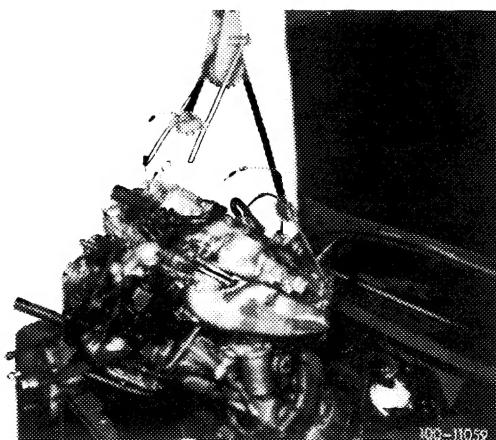
Note

When repairing engines 110, use radial sealing ring 000 997 90 41 (yellow-brown) and cut off with 0.5 mm projection.

Exception: On engines which are provided with a new or a newly machined (refinished) crankshaft and new crankshaft bearings during repairs, install radial sealing ring 000 997 69 41 (graphite-grey) and cut off with 1 mm projection.

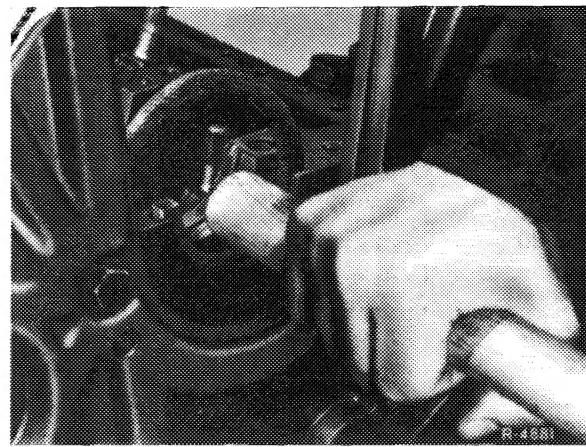
Replacing

- 1 Remove engine (01–030).
- 2 Remove crankshaft.



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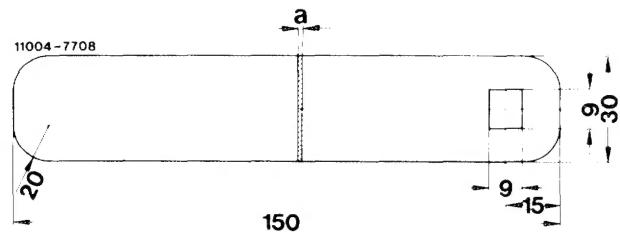
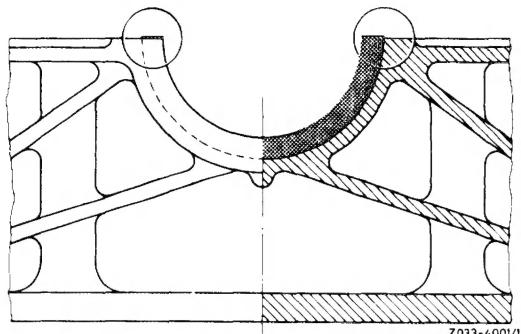
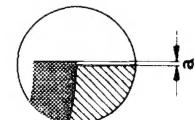
3 Place radial oil seal in crankcase and oil pan, and rub in with an oiled hammer handle.



4 To provide an overlap, cut off radial oil seal in crankcase and oil pan about 0.5 mm or 1.0 mm above mating surface.

Note: For cutting off, a self-made gauge according to drawing can be used.

Radial sealing ring, part no.	Dimension a (mm)
000 997 69 41 (graphite-grey)	1.0
000 997 90 41 (yellow-brown)	0.5



5 Coat radial oil seal with oil before installation of crankshaft.

6 Install crankshaft.

7 Install oil pan, turn crankshaft and check for easy movement.